

इंटरनेट

मानक

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“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 7989 (1976): Pliers for Internal Circlips [PGD 5:  
Assembly Hand Tools]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”



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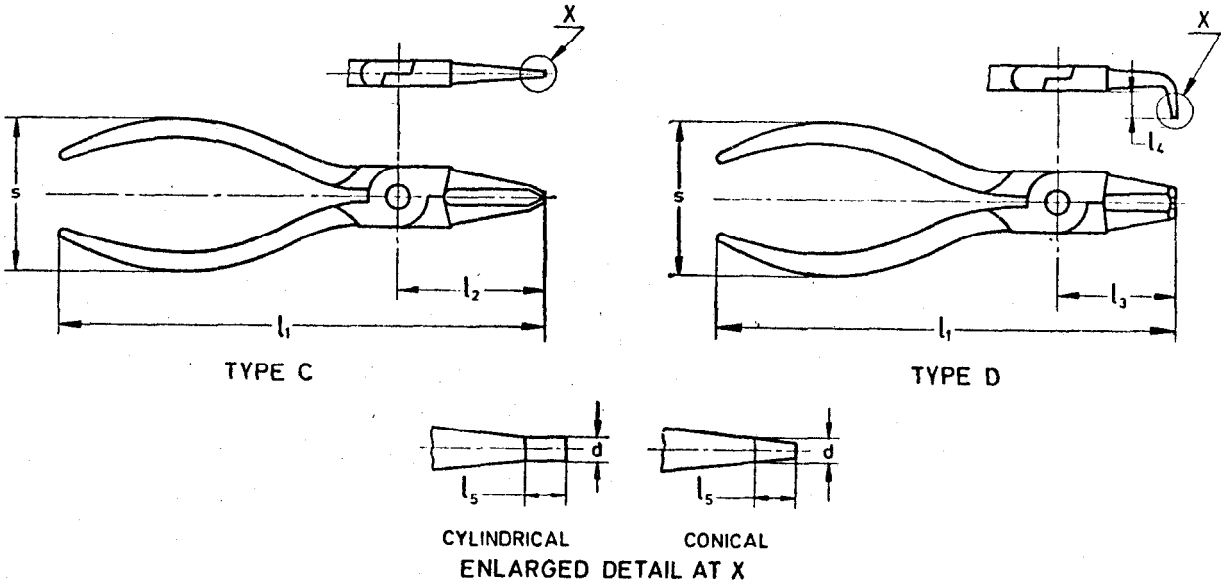


Indian Standard

SPECIFICATION FOR  
PLIERS FOR INTERNAL CIRCLIPS

1. **Scope** — Covers requirements for pliers for internal circlips conforming to IS:3075-1965 'Dimensions for circlips'.

2. **Dimensions**



All dimensions in millimetres.

Nominal Size*	d		l <sub>1</sub>		l <sub>2</sub>	l <sub>3</sub>	l <sub>4</sub>	l <sub>5</sub>		s Approx	For Internal Circlips†
	Nom	Tol	Nom	Tol				Nom	Tol		
8	0.9	+0 -0.1	135	± 10	38	28	12	1.5	+0 -0.2	45	8 to 25
19	1.8	+0 -0.1	175	± 12	50	38	14	2.5	+0 -0.3	45	19 to 60
40	2.3	+0 -0.15	215	± 15	63	50	16	3.5	+0 -0.4	50	40 to 100
85	3.2	+0 -0.15	290	± 15	70	70	20	4.5	+0 -0.4	50	85 to 165
125	3.5	+0 -0.15	500	± 20	100	100	25	6.0	+0 -0.4	60	125 to 300

\*Indicates the minimum size of circlip for which the plier shall be used.  
†Conforming to IS : 3075-1965.

3. **Hardness** — The hardness of the jaws shall be 440 ± 60 HV 5 ( ≈ 44 ± 5 HRC ).

4. **General Requirements** — The material, manufacture, workmanship, finish, preservation, packing and sampling shall conform to IS:2615-1964 'General requirements for pliers, pincers and nippers'.

5. **Designation** — A plier of Type C and of nominal size 40 mm shall be designated as:  
Plier C40 IS : 7989

**6. Test** — The pliers shall be tested by closing five times the number and size of internal circlips as indicated below and on the completion of the test the pliers shall show no sign of deformation:

Nominal Size	Size of Internal Circlips*	Number of Circlips†
8	25	2
19	60	2
40	100	2
85	165	1
125	300	1

\*Conforming to IS : 3075-1965.  
†For testing of pliers of nominal size, up to and including 40 mm, the two circlips shall be soldered together.

**7. Marking** — The pliers shall be marked with type, nominal size and manufacturer's name, initials and/or recognized trade-mark.

**7.1 ISI Certification Marking** — Details available with the Indian Standards Institution.

## EXPLANATORY NOTE

While preparing this standard assistance has been derived from DIN 5256-1965 'Zangen für Sicherungssinge für Rohnungen (Pliers for retaining rings for bores)', issued by Deutsches Institut für Normung.